




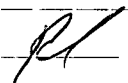


# Work Order ID 64292

Wednesday, December 01, 2010 1:20:35 PM

Page 1


Item ID:	D3836-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Rib Assembly (Basket Lid, LH)					
Start Date:	12/1/2010	Start Qty:	2.00	Cust Item ID:		
Required Date:	12/8/2010	Req'd Qty:	2.00	Customer:		


## Reference:

Approvals:	Process Plan:		Date:	10/12/1	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3836	Rev A								

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- cut D3836-1 and D3836-3 rib as per dwg D3836								
	2- remove identification markings								
	3- deburr								
	4- weld D3836-1 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836								
	5- weld D2327-3 spacer bushing as per dwg D3836 A/R_ER316 S.S. Rod Batch: 111585								
	6- grind weld flush where indicated on dwg								

130	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
									
QC	Memo	0.00							
Quality Control									

SAD 10-12-02


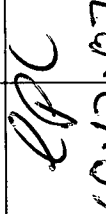

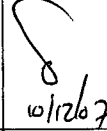

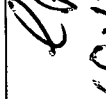

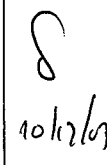
CP 10.12.07

10.12.08 2 0 3ERO/2/07

P107

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3836-041 PAR #: \_\_\_\_\_ Fault Category: Large Fals NCR: Yes No DQA: ✓ Date: 10/12/07  
 Resolution: rework Disposition: rework QA: N/C Closed: ✓ Date: 10/12/09




NCR: 64292		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/12/07	# 100.4	when welding D2307-3 spacer welder was rushing to get to next job and didn't pay attention to orientation of the spacer, welder set in wrong side of part.		-Drill out D2307-3 and Buyd welds. -Re weld in correct orientation as per DA.	 EO-21.01			10/12/07
		RL Lack of Attention. too many jobs on the ego.		D2307-3 B <u>64048</u>				10/12/07



NOTE: Date & initial all entries




# Work Order ID 64292

Wednesday, December 01, 2010 1:20:35 PM

Page 2

Item ID:	D3836-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Rib Assembly (Basket Lid, LH)					
Start Date:	12/1/2010	Start Qty:	2.00	Cust Item ID:		
Required Date:	12/8/2010	Req'd Qty:	2.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00		<i>Start</i>		<i>12</i> <i>24</i>			
150  Packaging Packaging	Identify as per dwg & Stock Location: <i>WA</i>  Memo	0.00 0.00		<i>SAD</i> <i>10-12-08</i>		<i>2</i>			
160  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							<i>10/12/09</i> <i>MF</i> <i>10-12-08</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, December 01, 2010 1:20:43 PM

Page 1

Work Order ID: 64292

Parent Item: D3836-041

Parent Item Name: Rib Assembly (Basket 1 - d, LH)

Start Date: 12/1/2010

Required Date: 12/8/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2327-3

Manufactured

No

100

Each

25.0000

1



Spacer Bushing

Location

Loc Qty

Loc Code

WA

25

58974

1

60320

1

60952

2

64048

21



*Pl 10-12-07*

M304TS0.750W.065

Purchased

No

100

f

1,062.852

1.7808

3,749.053



304 SQ Tube .75x.75x.065W

Location

Loc Qty

Loc Code

MAT

1015.74795

112398

0

115494

4.4725

115593

11.27545

116267

1000

WA

47.104485

115274

4.712185

115901

42.3923



*SAD 10-12-02*

*3,749.1*

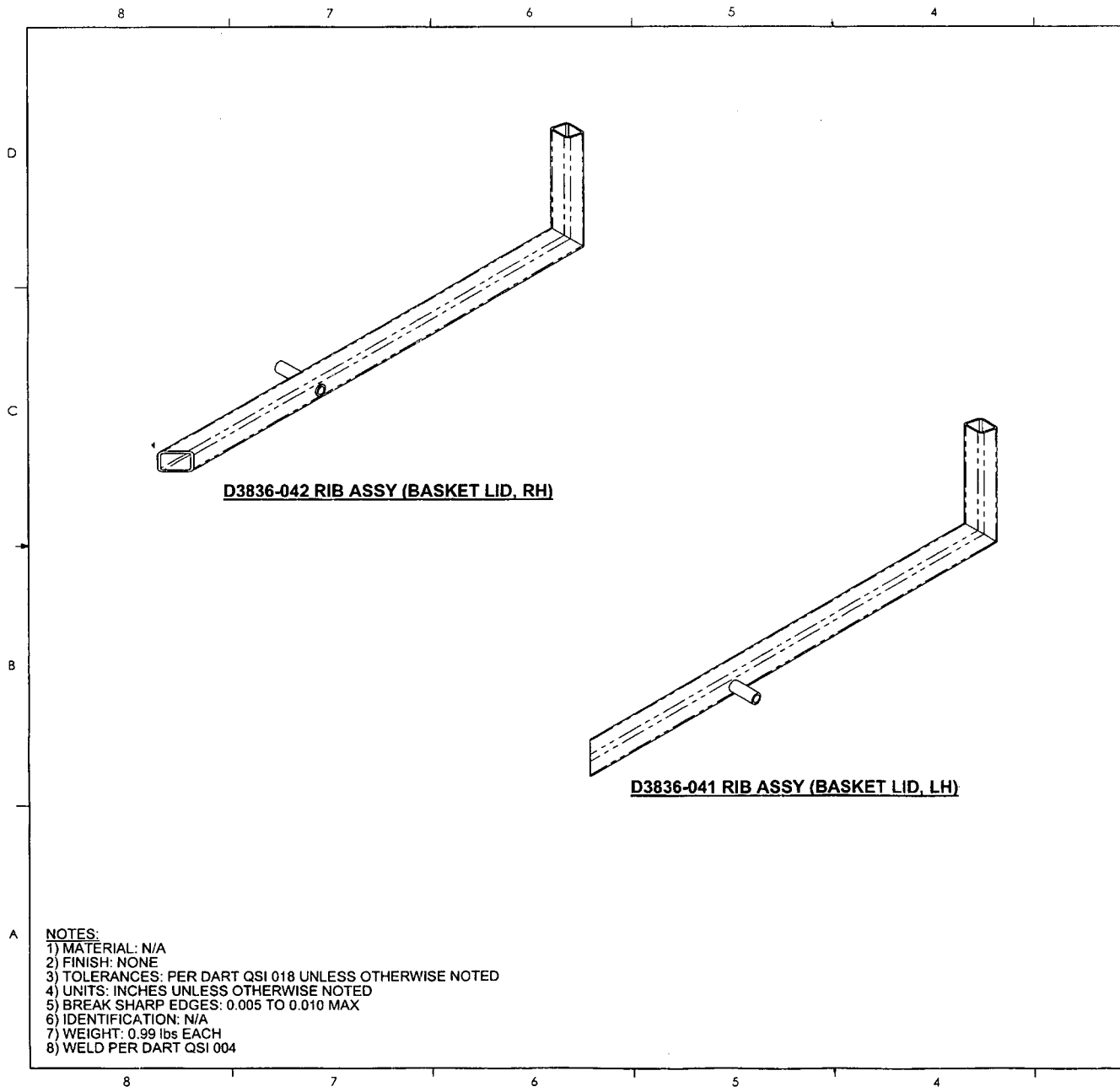
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 44292

*PS 10-12-1*

RELEASED  
*24/11/8 MB*

- NOTES:  
1) MATERIAL: N/A  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 0.99 lbs EACH  
8) WELD PER DART QSI 004

A	NEW ISSUE	MB	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.24		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D3836		REV. A	SHEET 1 OF 3
TITLE RIB ASSY (BASKET LID)		SCALE	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

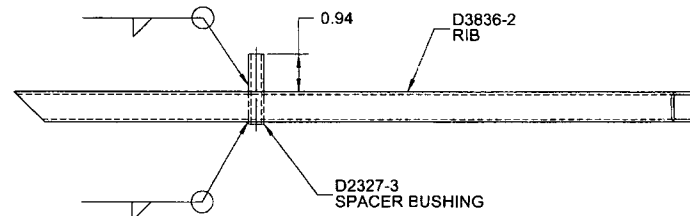
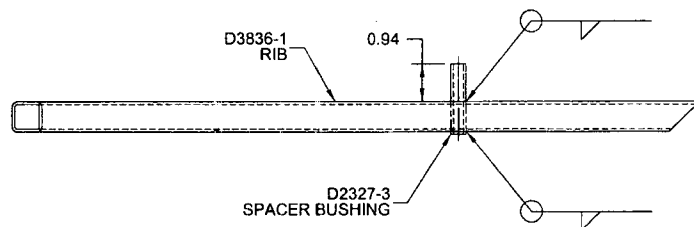
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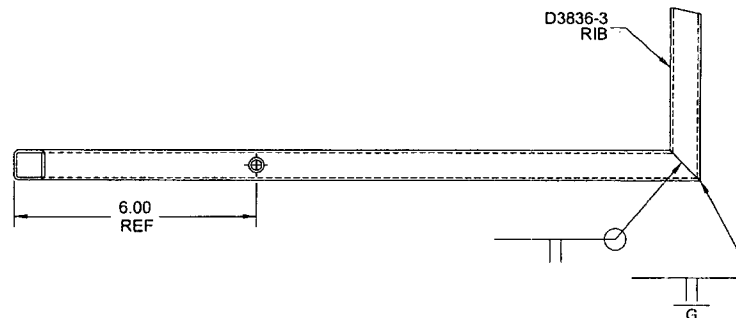
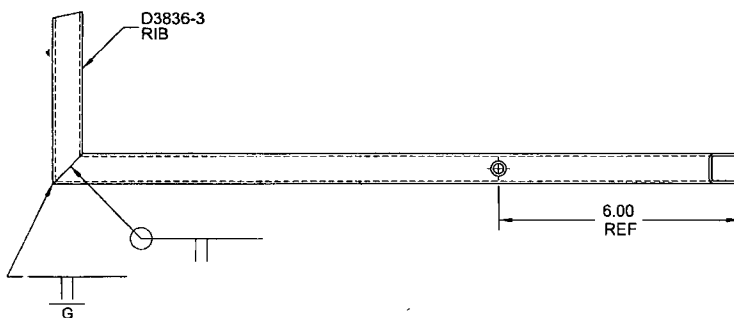
D

D



C

C



B

B

**D3836-041 RIB ASSY (BASKET LID, LH)**

**D3836-042 RIB ASSY (BASKET LID, RH)**

*Wb 64292*

**RELEASED**  
*08/11/18 M*

A

A

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>MS</i>	DRAWING NO.	REV. A
MFG. APPR.		<b>D3836</b>	SHEET 2 OF 3
APPROVED	<i>MS</i>	TITLE	SCALE
DE APPR.		<b>RIB ASSY (BASKET LID)</b>	NTS
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

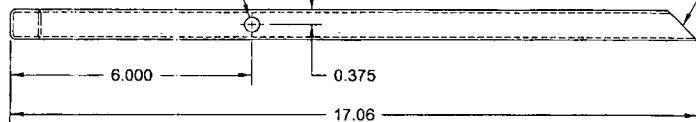
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

0.75 X 45°  
CHAMFER

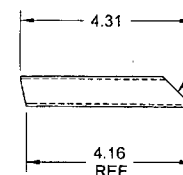


$\phi 0.375^{+0.020}_{-0.000}$  THRU



0.75 X 45°  
CHAMFER

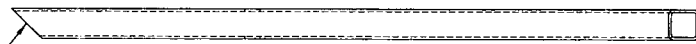
**D3836-1 RIB**



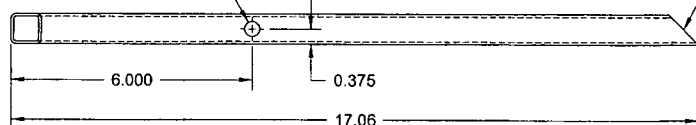
0.75 X 45°  
CHAMFER

**D3836-3 RIB**

0.75 X 45°  
CHAMFER

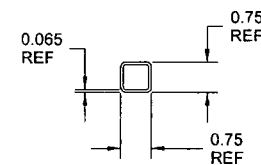


$\phi 0.375^{+0.020}_{-0.000}$  THRU



0.75 X 45°  
CHAMFER

**D3836-2 RIB**



**TYPICAL SECTION  
VIEW**

**RELEASED**  
08/11/81

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

DESIGN	1	<b>DART AEROSPACE LTD</b>	
DRAWN	5	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.	ASS	D3836	SHEET 3 OF 3
APPROVED	ASS	TITLE	SCALE
DE APPR.	ASS	RIB ASSY (BASKET LID)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries